

# Work Order ID 50528

July 14, 2009 8:56:38 AM



Page 1

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 17/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 21/07/2009 Req'd Qty: 7.00



Customer:

Reference:

*09.07.14*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion to .820"

*(43922) mut 09/07/14*

*7*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA834

Dwg Rev: A

Folio Rev: A

Deburr

*mut 09/07/14*

*7*

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Page 2

Item ID: D3789-7	Accept		Setup Start	
Revision ID: A			Stop	
Item Name: Clamp				
Start Date: 17/07/2009	Start Qty: 7.00		Cust Item ID:	
Required Date: 21/07/2009	Req'd Qty: 7.00		Customer:	

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Run	Start	
	Stop	






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 	QC2- Inspect parts off machine FAI/FAIB	0.00				7			
QC Quality Control	Memo	0.00	mmw 09/07/15						
120 	QC8- Inspect parts - second check	0.00				7			
QC Quality Control	Memo	0.00	JIT 09/07/15						
130 	Chemical Conversion Coat per QSI005 4.1	0.00				(27)			
HandFinish Hand Finishing	Memo	0.00	UMD 09/07/15						



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Page 3

Item ID: D3789-7 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Clamp  
Start Date: 17/07/2009 Start Qty: 7.00  Cust Item ID:  
Required Date: 21/07/2009 Req'd Qty: 7.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC3- Inspect Part Finish  Memo <i>HL</i>	0.00  0.00							
			09-07-15	(X7)					
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo *****Mask bearing bore prior to powder coat***** START TIME: <u>1:10pm</u> OVENTEMPERATURE: <u>320°F</u> FINISH TIME: <u>1:40pm</u>	0.00  0.00							
			M112148	09-07-05	(X7)				
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			09-07-15			7	<del>15</del>		

**Work Order ID 50528**

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Page 4

Item ID: D3789-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 17/07/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 21/07/2009 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: <u>467</u>	0.00							
Packaging	Memo	0.00				94/16		SP 7x	
Packaging									
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/21

-ME 09-07-17

# Picklist Print

Page 1

July 14, 2009 8:56:37 AM

Work Order ID: 50528



Parent Item: D3789-7RevA



Parent Item Name: Clamp



Start Date: 17/07/2009

Required Date: 21/07/2009

Comments:

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1 		Manufactured	No			100	f	767.4300	0.5158			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

767.43

43722

219.5

44529

22.39

45800

525.54

43722

.5158

mjt 09/07/14

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50528
<b>Description:</b> Clamps		<b>Part Number:</b> D3789-7
<b>Inspection Dwg:</b> A	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	±.03	4.19	✓			
3.45	±.03	3.44	✓			
.75	±.03	.75	✓			
1.50	±.03	1.50	✓			
.41	±.03	.41	✓			
.40	±.03	.39	✓			
.38	±.03	.37	✓			
R 1.38	±.03	R 1.38	✓			
R .20	±.03	R .20	✓			
R .06	±.03	R .06	✓			
R .34	±.03	R .34	✓			
R .03	±.03	R .03	✓			
R .38	±.03	R .38	✓			
Ø .257	+ .005 - .000	Ø .259	✓			

<b>Measured by:</b> mmw	<b>Audited by:</b> DTP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/15	<b>Date:</b> 09/07/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

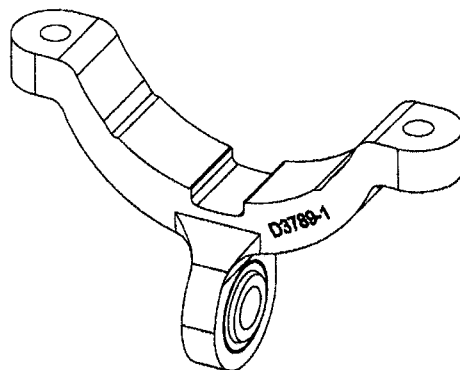
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

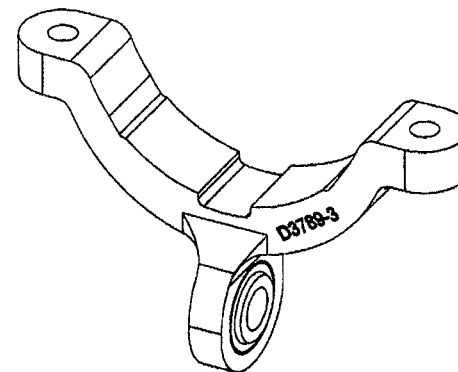
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

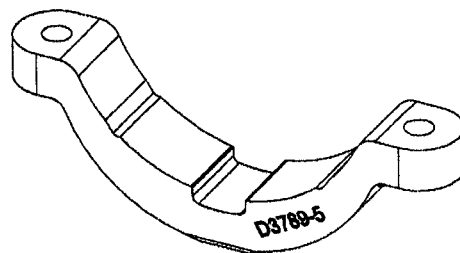
NOTE: Date & initial all entries



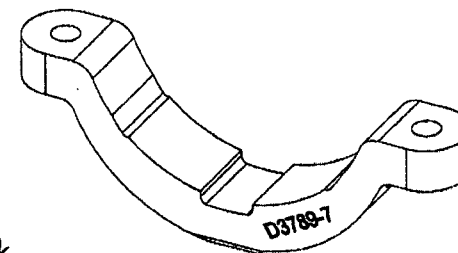
**D3789-1 CLAMP**



**D3789-3 CLAMP**



**D3789-5 CLAMP**



**D3789-7 CLAMP**

**DEO ATTACHED**

**RELEASED**  
08/12/21

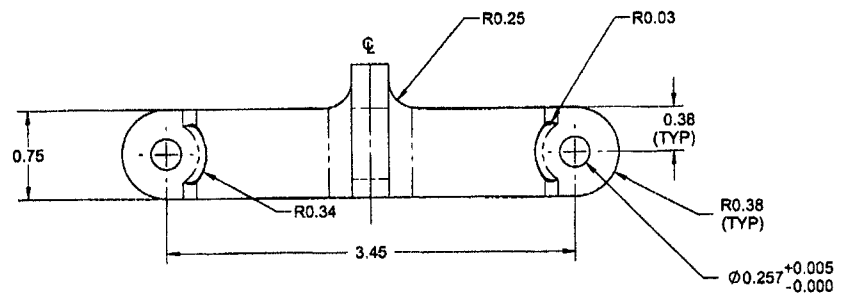
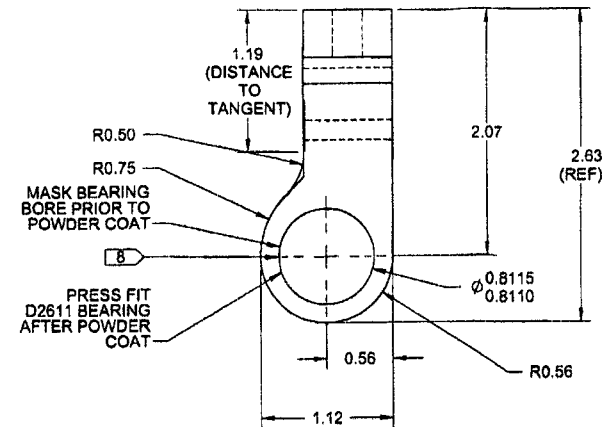
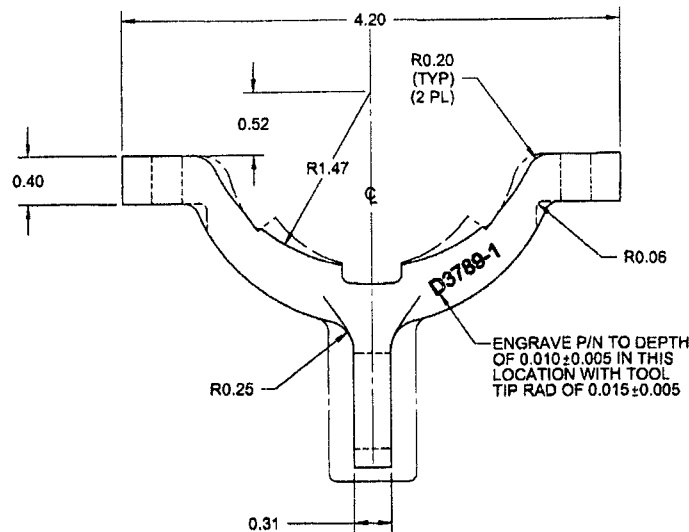
50528

**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT Q

A NEW ISSUE		HS	08.05.21
REV.	DESCRIPTION		BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO	REV. A
MFG. APPR.		D3789	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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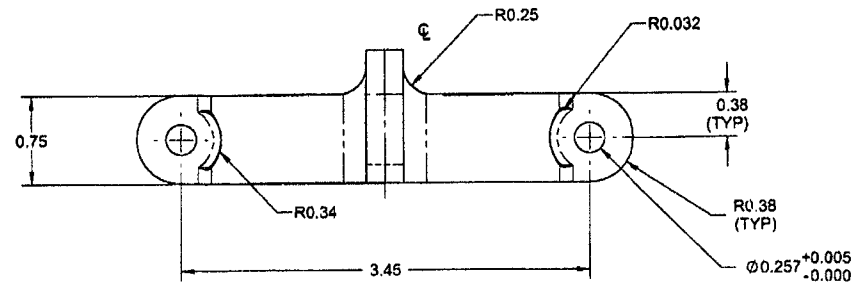
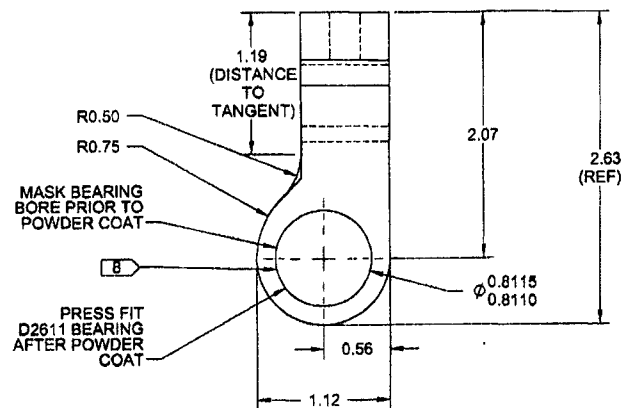
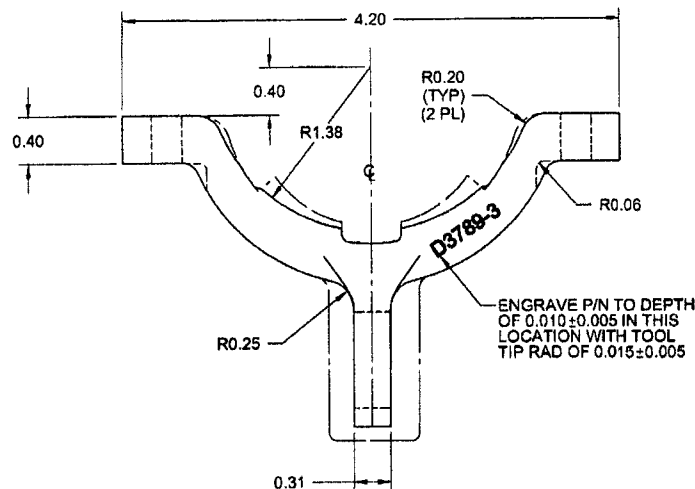
**D3789-1 CLAMP**

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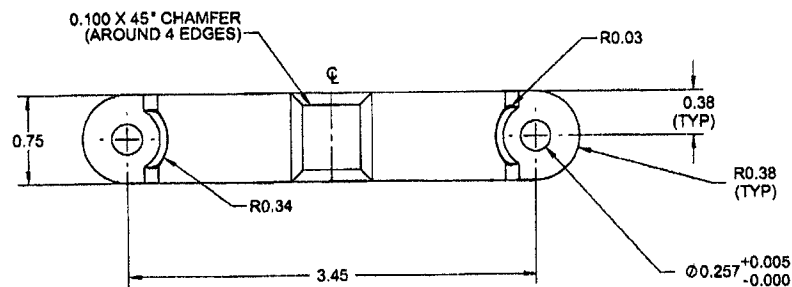
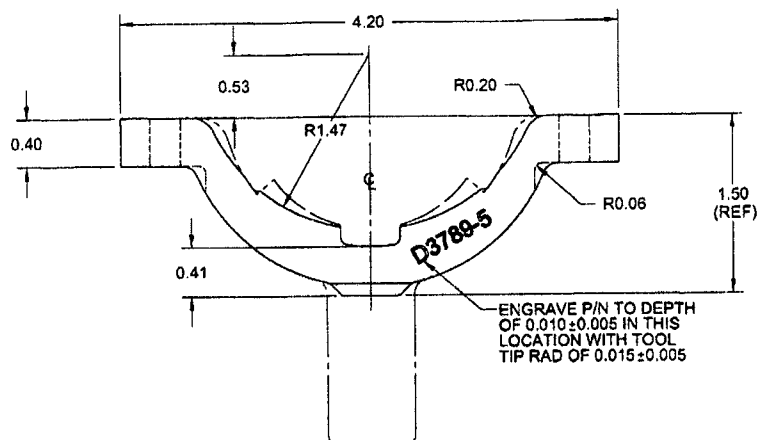
**D3789-3 CLAMP**

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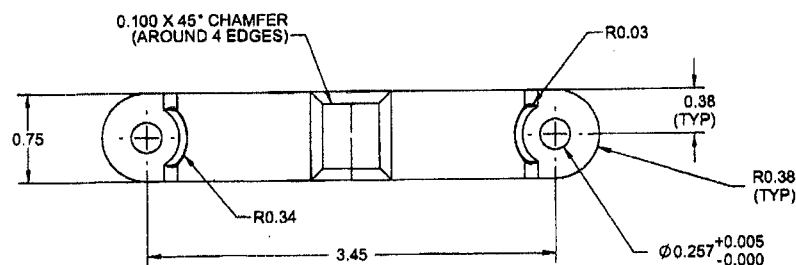
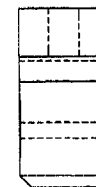
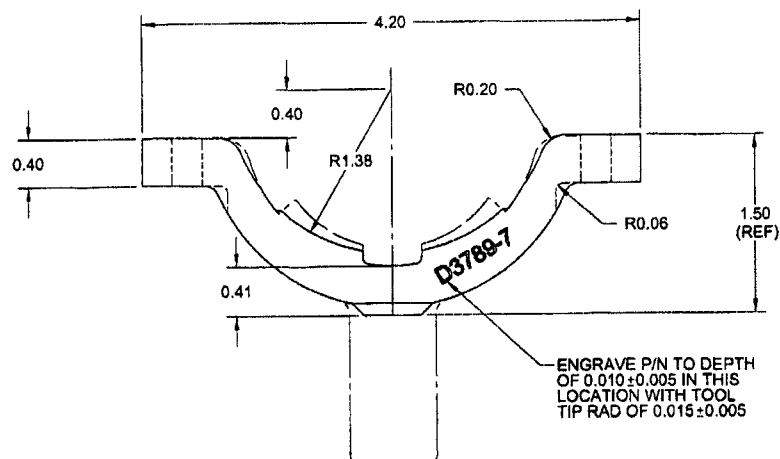
**D3789-5 CLAMP**

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**D3789-7 CLAMP**

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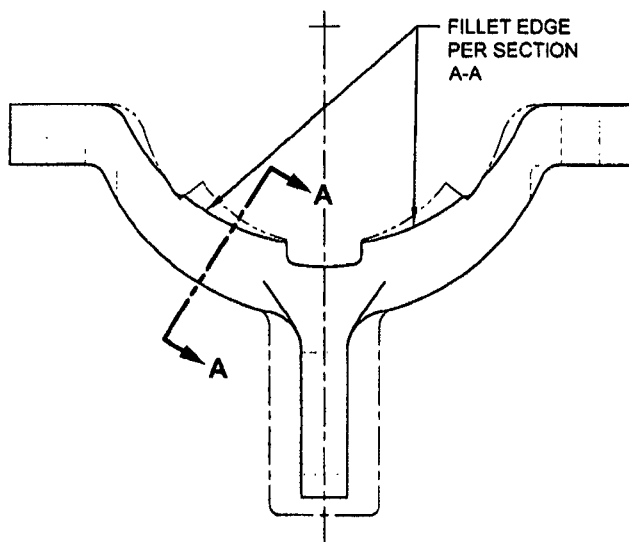
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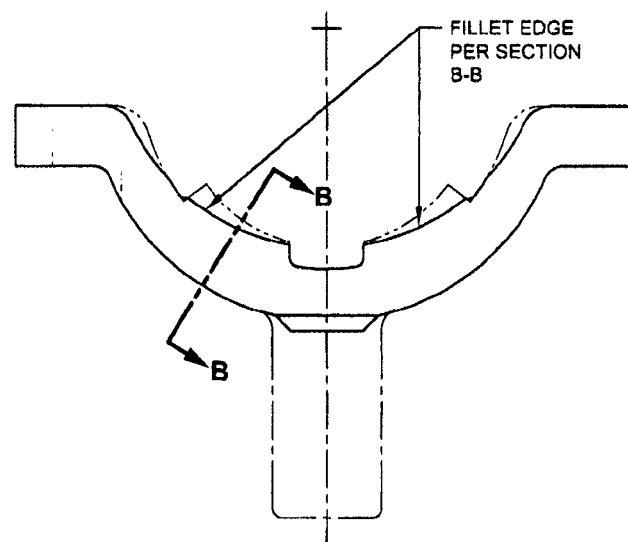
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DRAWN <i>AJS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23	DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



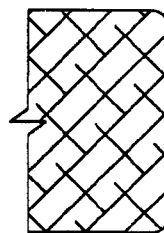
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

50528

**RELEASED**  
09/05/04 *[Signature]*

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